

Split -1

Work Order ID 86348 -1

\*86348\*

Page 1

Item ID: D2274

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Radius Block

Stop \*NS2\*

Start Date: 27/06/2012 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Approvals: Process Plan: MLI

Date: 12/06/28 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00

\*100\*

SHEAR

Shear

Memo

0.00

OK 12/07/16

200 x

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

OK 12/07/17

71

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

DAS 14 12/07/17

71

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86348

June-27-12 3:20:59 PM

\*86.348\*

Page 3

Item ID: D2274

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Radius Block

Start Date: 27/06/2012 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

*Jul 12.07-18 71 Ø*

140

Small Fab

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

TumbleDeburr any rough edges after tumbling

*71 7/12-7-18*

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

*71 7/12-7-18*



W/O:		WORK ORDER CHANGES					
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June-27-12 3:20:59 PM

\*86348\*

Page 3

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Accept

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Revision ID:

Stop \*NS2\*

Item Name: Radius Block

Start Date: 27/06/2012 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

SP

12-7-18

170

Identify as per dwg & Stock Location: 9

0.00

\*170\*

Packaging

Memo

0.00

Packaging

7k

sf

12-7-18

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

12/7/18

MF  
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

June-27-12 3:21:03 PM

Page 1

Work Order ID: 86348

\*86348\*

Parent Item: D2274

\*D2274\*

Parent Item Name: Radius Block

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	114.5030	0.0916	19.28421			

\*M6061T6B00750X00 125\*

\*\*

6061-T6 Bar .750 x .125

## Location

## Loc Qty

## Loc Code

MAT001

111.168

116406

2.75

117653

8.418

→ 122081

100

MAT003

3.335

120603

3.335

20

OK 12/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

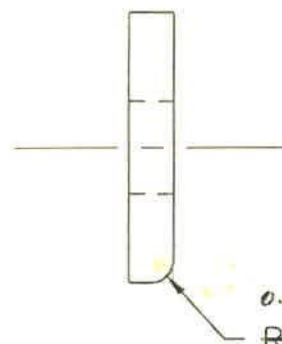
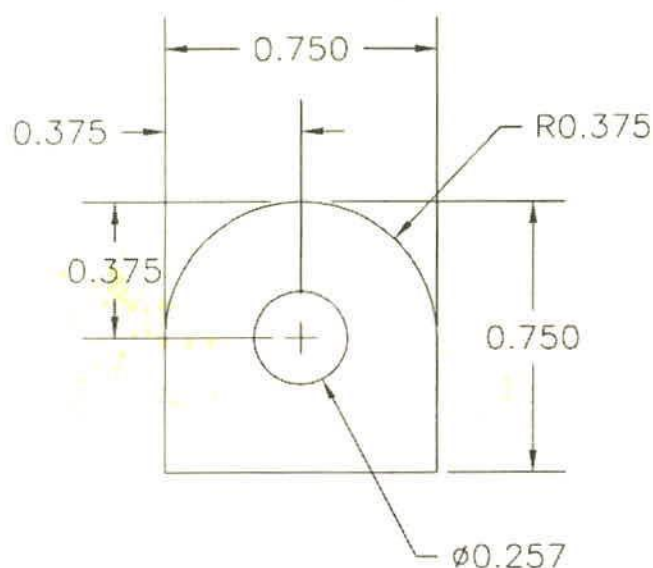
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MP</i>	APPROVED <i>CS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

**RELEASED**  
*98/08/15 KE*

SHOP COPY  
RETURN TO  
ENGINEERING  
LINE CONTROL LED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *86348* *145*  
*12/06/28*

*00.05.16*  
*00.05.16*

0.063 x 45° CHAMFER  
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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